

Date: Friday, 23/05/2008 12:41:40 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: 205 SKIDTUBE "I" BEAM		
<b>Job Number</b>	: 39458			<b>Part Number</b>	: D2596		
<b>Estimate Number</b>	: 10346			<b>Drawing Number</b>	: D2596 REV D		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 23/05/2008 <b>S.O. No.</b> :			<b>Drawing Revision</b>	: D		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / / <b>Type</b> : SKIDTUBES			<b>Due Date</b>	: 06/06/2008 <b>Qty:</b> 4 <b>Um:</b> Each		
<b>Previous Run</b>	: 39426						
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JL</u> 08.5.23						
<b>Comment</b>	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M						
	Est Rev:E 07-07-09 Incorporated DEO 9183 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Extn - "I" Beam Web 4"	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4"			
	Pick;		
	Qty	Part Number	Description
	1	D2500-3-100	Extrusion
Batch <u>33940</u> <span style="float: right;">ET 08-05-27</span>			
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
<b>Comment:</b> LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
<i>SL 8-5-27</i>			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
<i>SL 8-5-27 (4)</i>			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP			
<i>BE 08-05-27 (4)</i>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

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Part Number: D2596

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

SL 8-5-27

(4)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/28/J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MP 08-05-27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

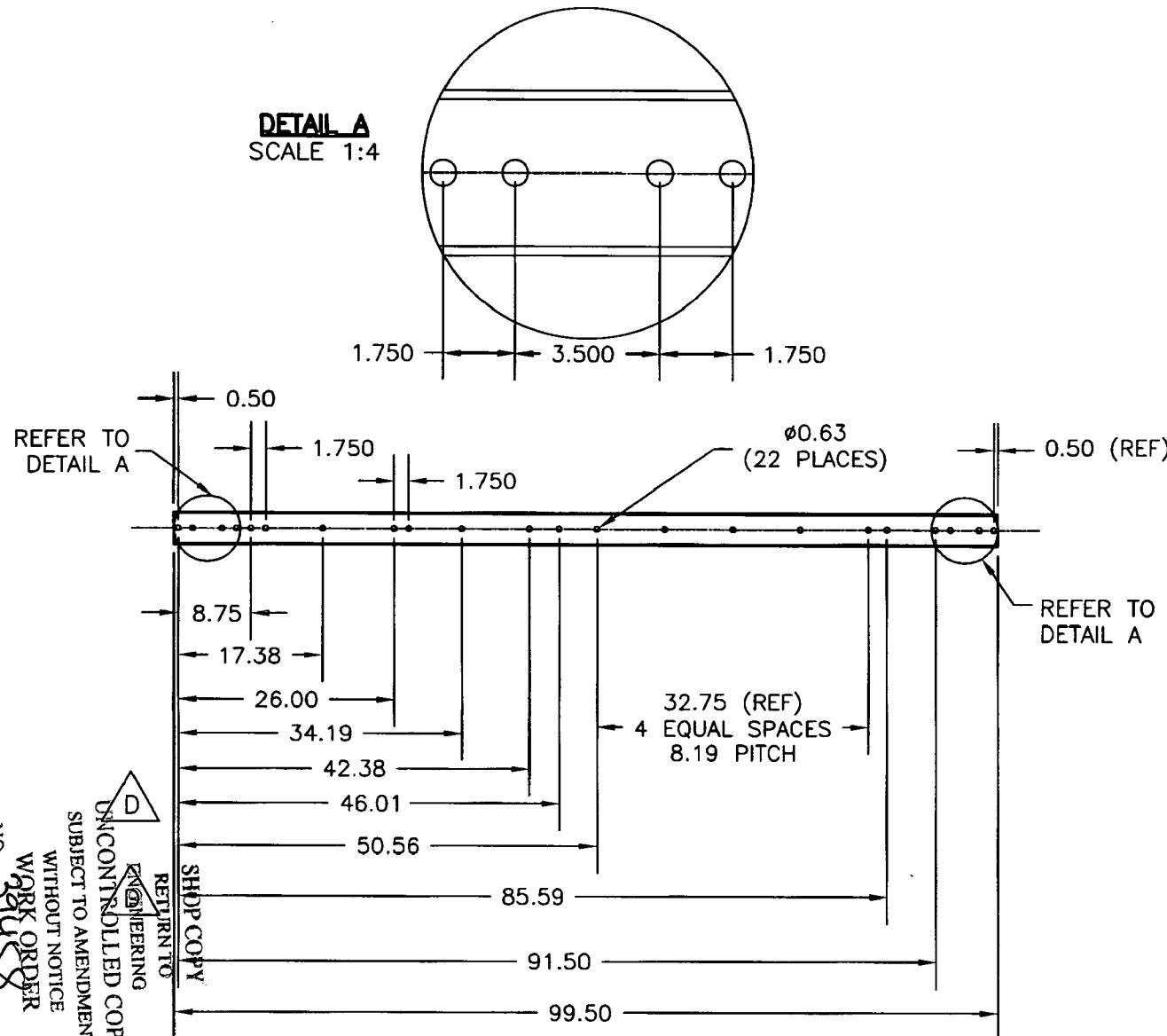
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
R 07/04/98

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D2596	REV. D	SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020